DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019820
Date Inspected: 27-Jan-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 630
OSM Departure Time: 1500
Location: Job Site

CWI Name: See below

Inspected CWI report:	☑ Yes	☐ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 6E-pp44-E3-1, 1W-pp10.5-W5, 6E-pp46.5-E2, 8E-pp61.5-E2 and the following observations were made:

6E-pp44-E3-1
The QA Inspector randomly observed the ABF welder Salvador Sandoval begin performing the SMAW root pass at the above identified location. The QA Inspector randomly observed the SE QC Inspector Steve McConnell monitoring the in process welding parameters. The QA Inspector noted the weld joint was approximately 10% complete at the time of the QA Inspectors visit. The QA Inspector randomly observed the ABF welder continue the SMAW root/fill pass and complete it on the QA Inspectors shift. The QA Inspector randomly observed the SMAW parameters were 5/32” E7018 low hydrogen electrodes with 150 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A R1. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on this date. The QA Inspector noted the weld reinforcement was not ground flush on the QA Inspectors shift. The QA Inspector randomly observed the ABF welder begin the fit up of the next lifting lug hole identified as 6E-pp44-E3-4. The QA Inspector noted no welding was performed during the QA Inspectors shift.

For the remainder of the QA Inspectors shift, the Lead QA Inspector Rick Bettencourt performed QA ultrasonic testing (UT) verification of access holes that were previously turned over by the SE QC Inspector Bonifacio Daquinag. The QA Inspector performed approximately 10% UT verification of the following weld joints:

1W-pp10.5-W5
6E-pp46.5-E2
8E-pp61.5-E2

The QA Inspector noted no rejectable indications were located at the time of the testing. For additional information reference TL-6027 for this date. The QA Inspector noted the weld identified above as, 8E-pp61.5-E2 was inadvertently rejected on a TL-6027. The QA Inspector generated an additional TL6027 for 1-27-11 accepting the welds in accordance with AWS D1.5-02 table 6.3.

Summary of Conversations:

no pertinent conversation noted on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Sang Le 916-764-5650, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer